

Work Order ID 65929-2

Thursday, January 27, 2011 11:27:26 AM

Page 1



Item ID: D3537-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

split

Start Date: 1/27/2011 Start Qty: 20.00



Required Date: 2/7/2011 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 1/27/2011 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr	Revision Nbr
----------	--------------

D3537	Rev C
-------	-------

100



FLOW WATER JET

0.00

1B1-1-28

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

(3)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

1B1-1-28

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

July 12s

QC

Memo

0.00

Quality Control

center
(132)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

(33)

Memo

0.00

Brake NC

Deburr if necessary! Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3. Form Joggle as per Dwg D3429 on brake using Jig DT8158

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

S u l o 2 l u 1

Counted
+32

150



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
116787 Weld hardcoat as per Dwg D3437

2 11-8-7 x17

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 1102108

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 1102108

(17)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref 4.3.5.6) per QSI005 4.3

0.00

m 11028.

Memo

0.00

START TIME:

2:35

OVEN TEMPERATURE:

FINISH TIME:

3:05.

17 BK 11-02-8.

W/O:		WORK ORDER CHANGES					
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Item Name: Wearpad

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC3- Inspect Part Finish

0.00

17 φ 11/02/08

QC

Quality Control

200



Identify as per dwg & Stock Location: FP/17. 0.00

17.

11/02-8.

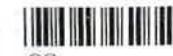
Packaging

Packaging

Memo

0.00

210



QC21- Final Inspection - Work Order Release

0.00

11/02/09 JF

QC

Quality Control

Memo

0.00

MF
11-02-08

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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, January 27, 2011 11:27:32 AM

Work Order ID: 65929



Parent Item: D3537-3



Parent Item Name: Wearpad

Start Date: 1/27/2011

Required Date: 2/7/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	254.5000	0.149	3.136842 		1/11/2011	20.00

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT	254.5	
111323	0	
116623	254.5	116623

(32)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	65929
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BS</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	11-1-28	Date:	11/01/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

W/O:		WORK ORDER CHANGES					
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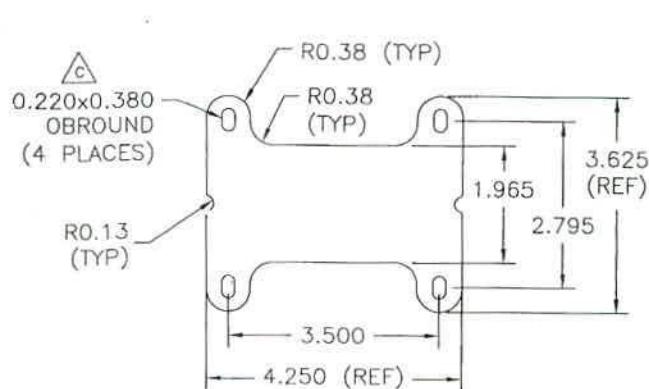
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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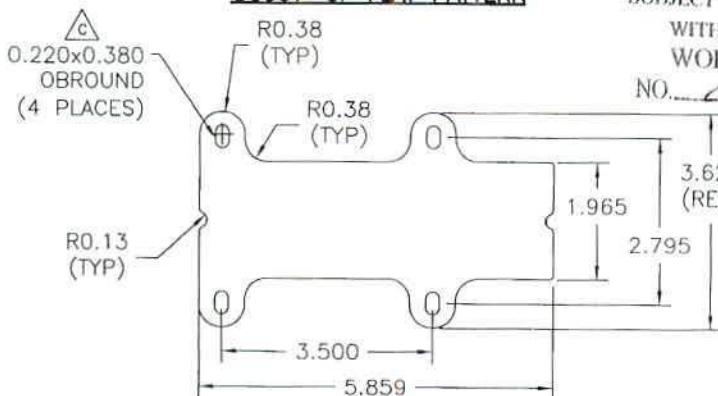
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65929
PL 11-01-17

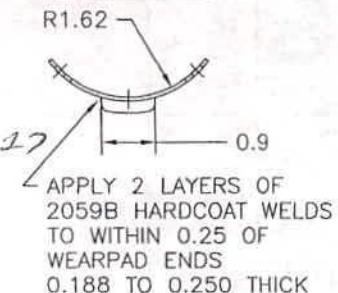
D3537-1F FLAT PATTERN



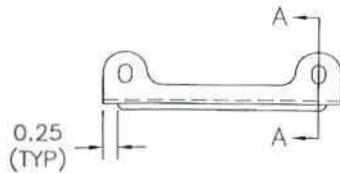
D3537-3F FLAT PATTERN



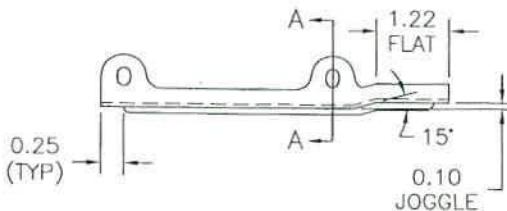
SECTION A-A



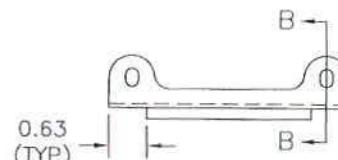
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



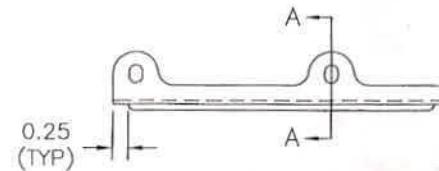
D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

DESIGN	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DRAWN BY	CB PH	DART AEROSPACE USA, INC. PORT HEDLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3537
DATE	07.04.13	REV. C SHEET 1 OF 1 TITLE WEARPAD SCALE 1:2

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